

Work Order ID 57943

April 21, 2010 8:40:45 AM

Page 1

Item ID: D3535-25

Accept

Setup Start

Revision ID:

Item Name: Wearshoe

Stop

Start Date: 21/04/2010 Start Qty: 12.00

Required Date: 28/04/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-4-21

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

364 .040

10-5-5

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-5-5

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/6/05/05

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57943

April 21, 2010 8:40:45 AM



Page 2

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326
Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

SB 10/05/10

(13)

2

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8 10/05/10

(+13)

150

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

START TIME: 1:00pm OVEN TEMPERATURE:

1:30pm FINISH TIME:

326°C

⇒ 10/05/10

(13)

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 57943

April 21, 2010 8:40:45 AM

Page 3

Item ID: D3535-25

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 21/04/2010 Start Qty: 12.00

Required Date: 28/04/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:





Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				13		BR 10-5-10.	
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FR 18</u> Memo	0.00 0.00	94	10/05/10		13	9		
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				13		BR 10-5-10.	10/05/12  MF 10-5-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:40:49 AM

Page 1

Work Order ID: 57943

Parent Item: D3535-25

Parent Item Name: Wearshoe

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	36.9800	6.4421			



304/316 .040 Sheet



B10-5-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

36.98

112885

5

113062

31.98

114574

114574



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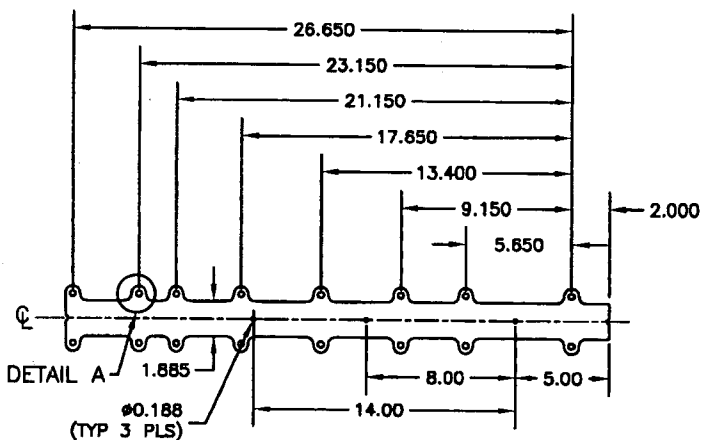
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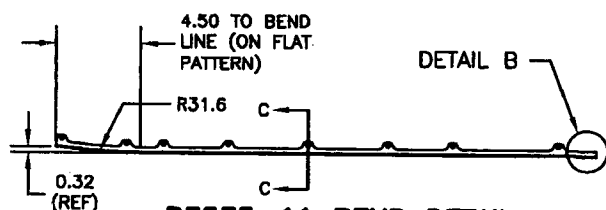
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07.04.24

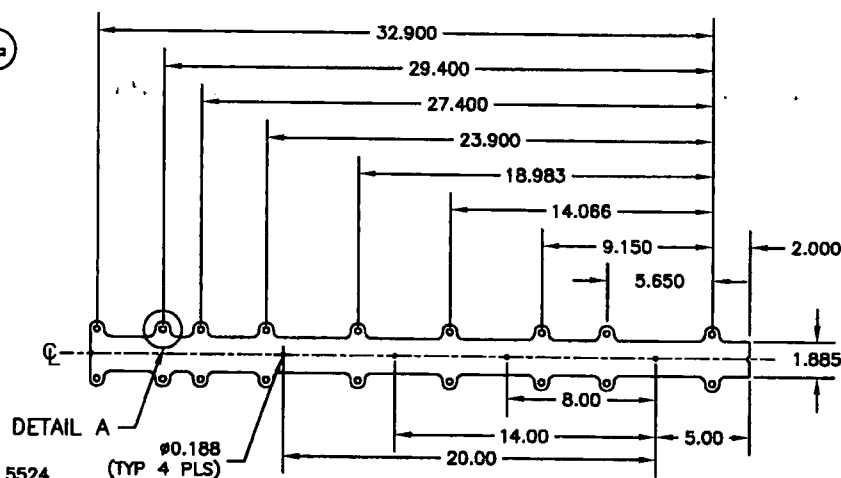
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57943
BS10-4-21



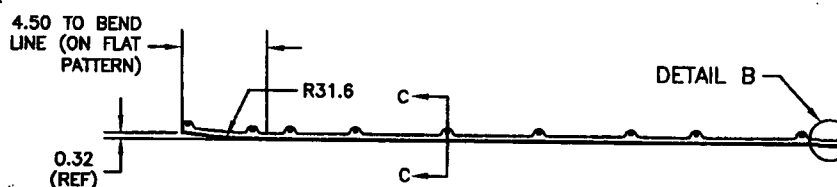
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535		
DATE		TITLE	SHEET 1 OF 7	
07.04.17		WEARSHOE	SCALE	
			1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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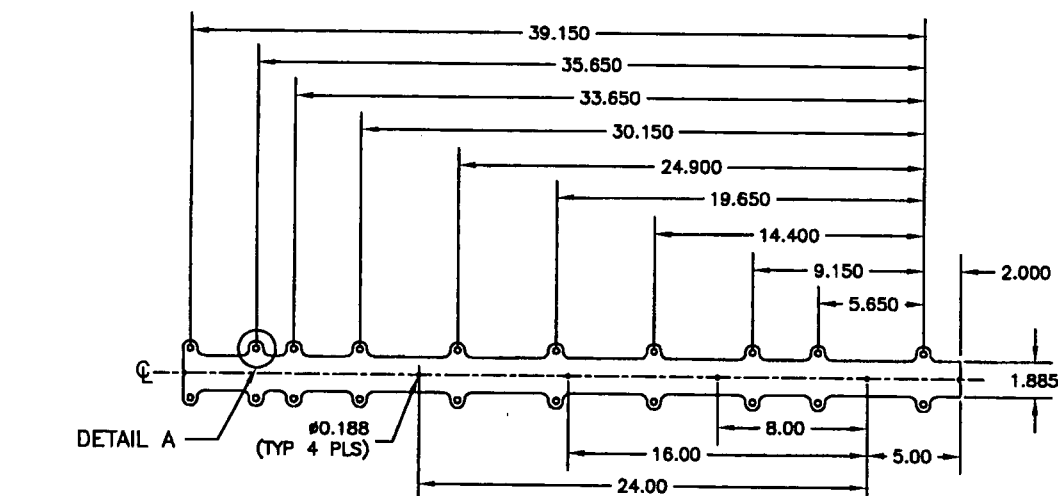
NOTE: Date & initial all entries

DART

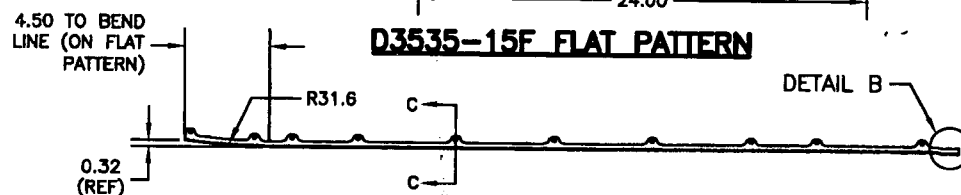
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07.04.24

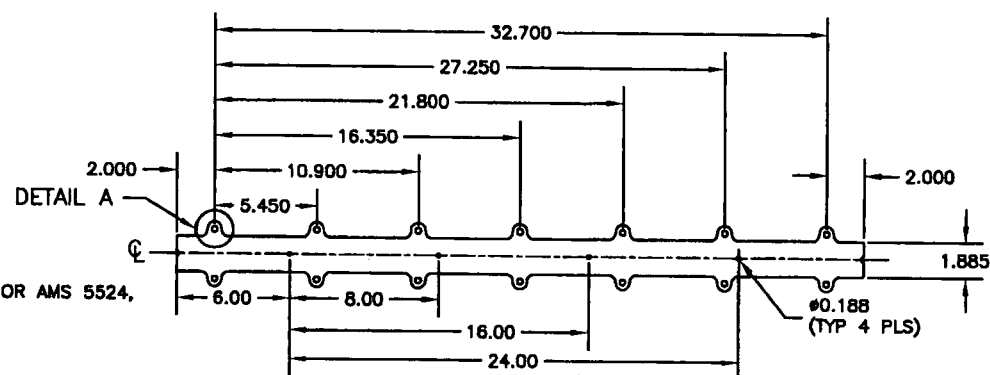
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



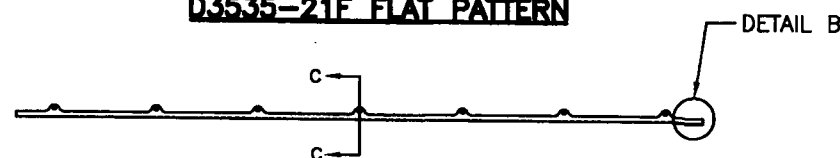
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 3) PART IS SYMMETRICAL ABOUT CL
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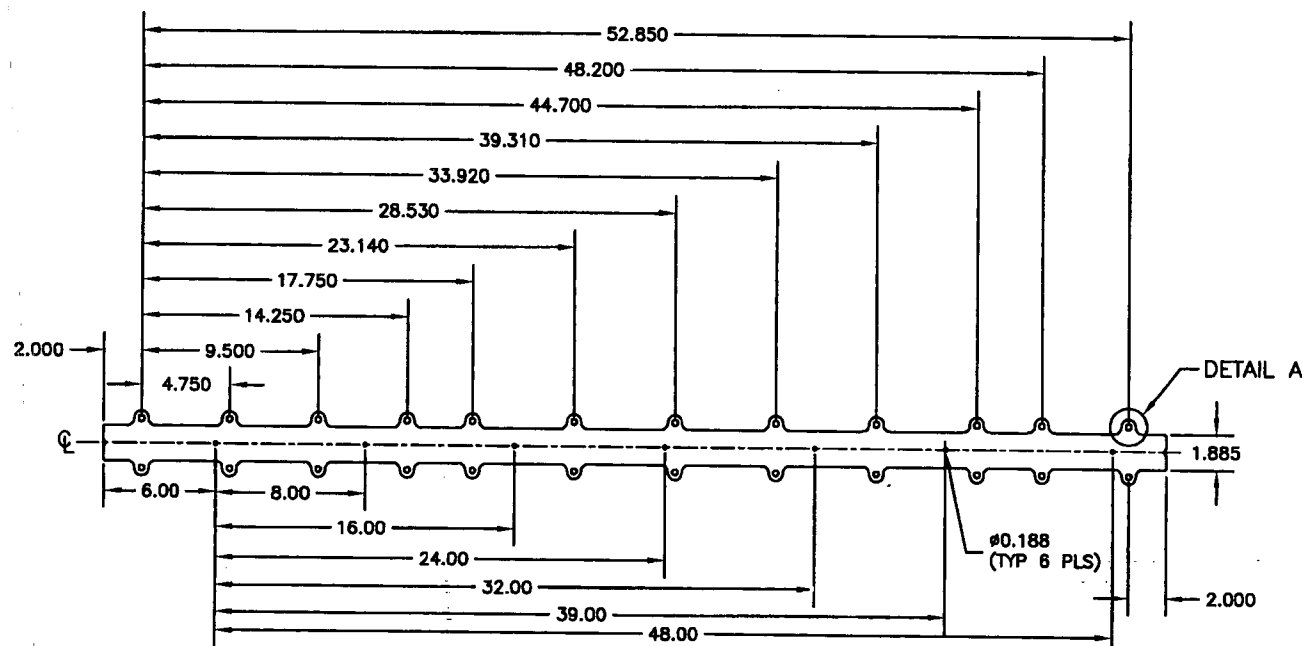
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07.04.24

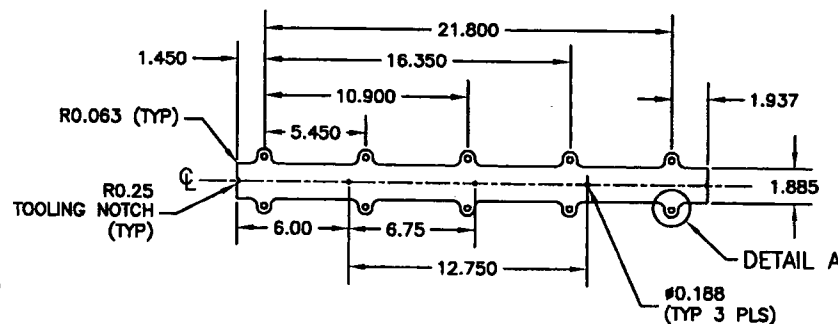
W10 57943

DESIGN	C.B.	DRAWN BY	M.H.	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REVISION
		WEARSHOE		
		SCALE	1:10	



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

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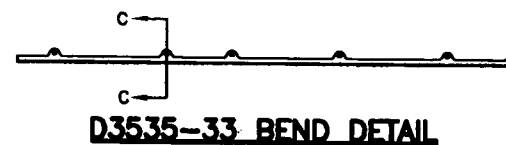
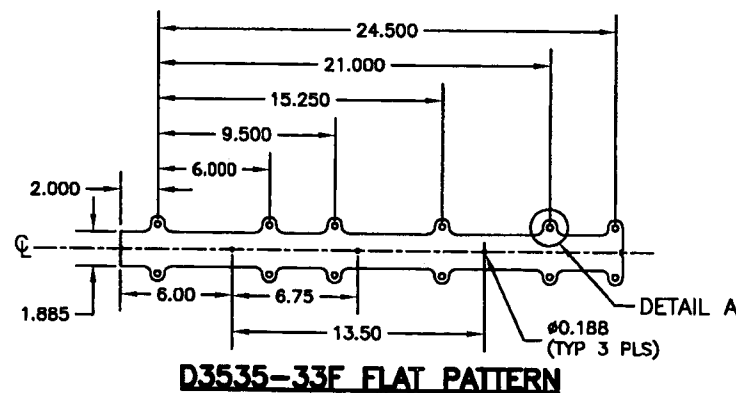
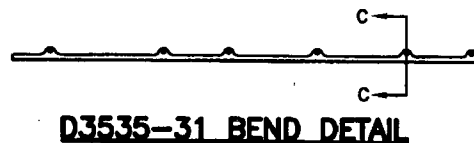
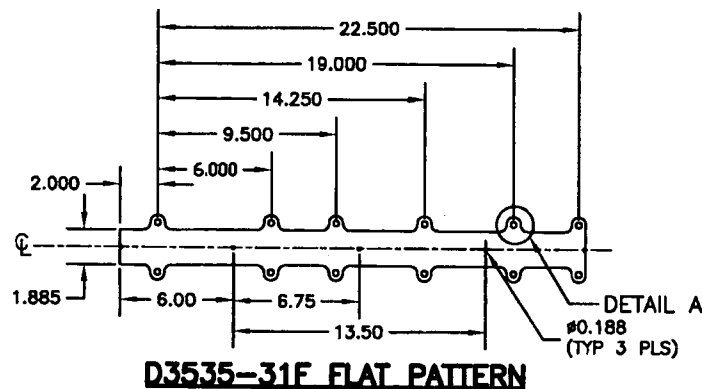
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07.04.17

W/O 57943

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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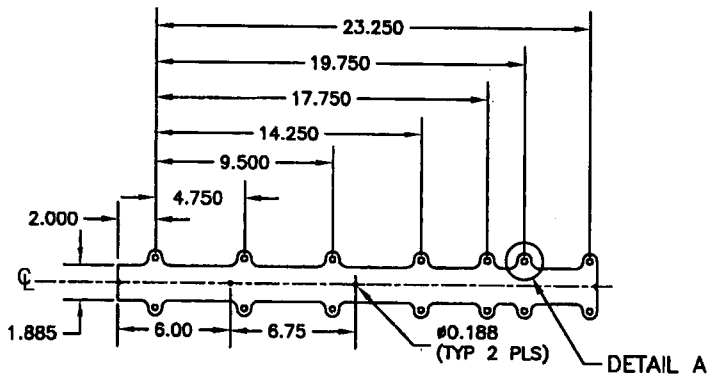
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07.04.17

wlo 57943

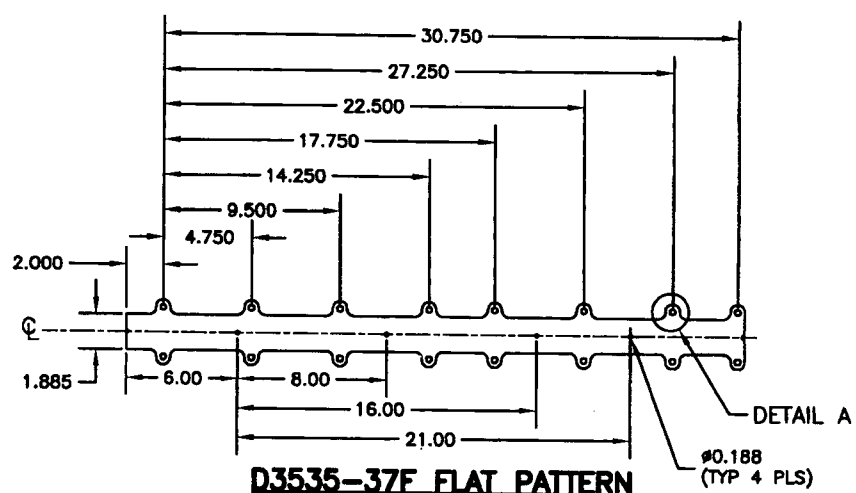
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 5 OF 7
		SCALE
		1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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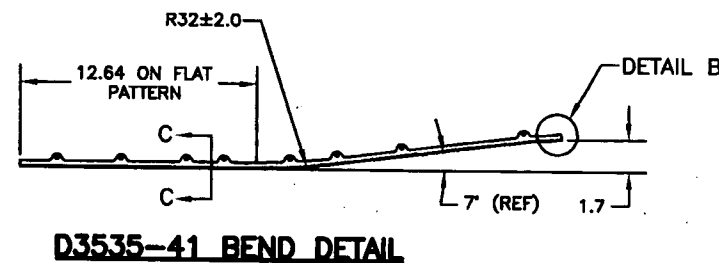
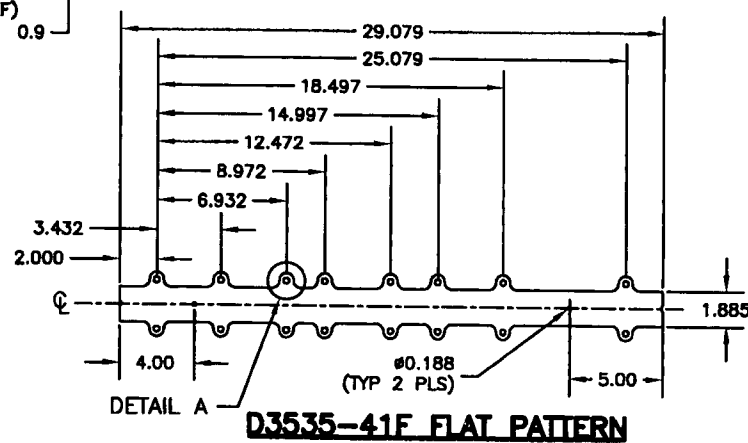
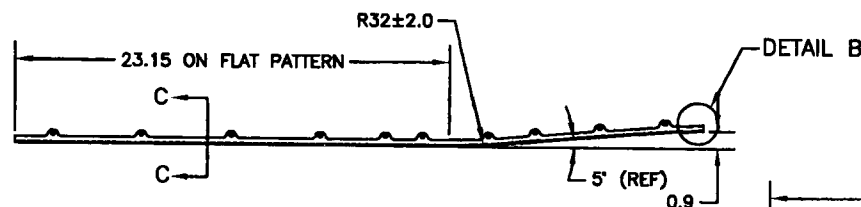
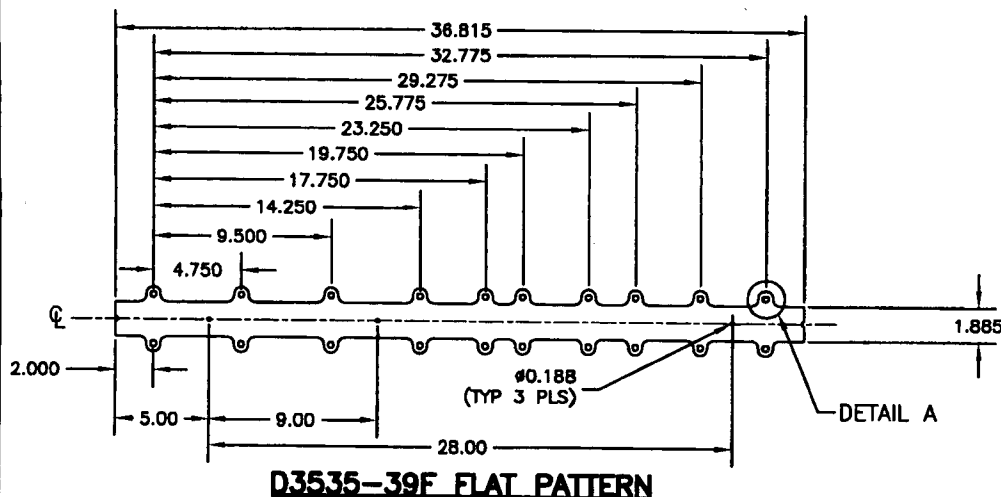
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DART

RELEASED
07.04.17

DESIGN	C.B.	DRAWN BY	M	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET	6 OF 7	
		REV.	B	



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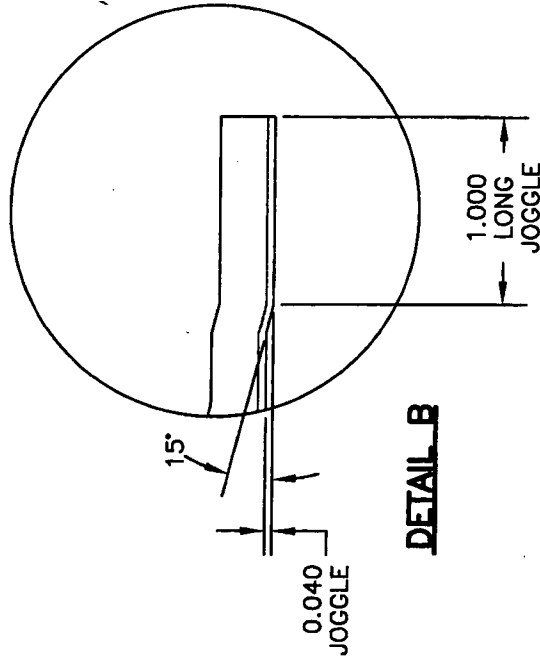
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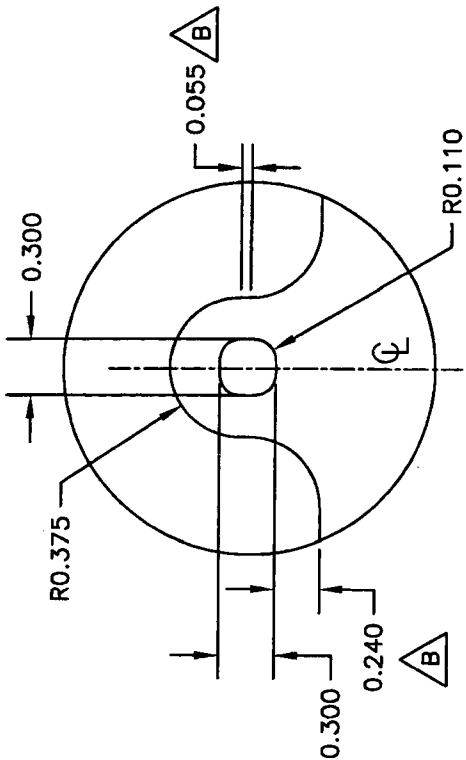
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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

RELEASED
07.04.24

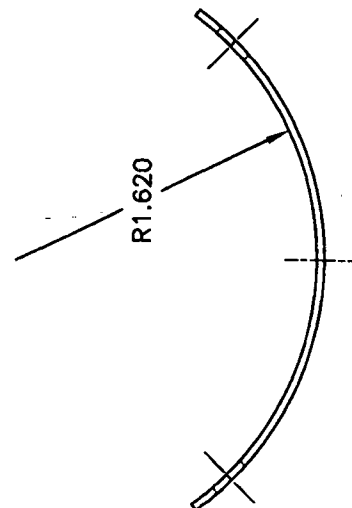


DETAIL B

w/o 579413



DETAIL A



SECTION C-C

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